

# Work Order ID 60212

Monday, June 28, 2010 3:26:47 PM



Page 1

Item ID: D3220-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/28/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10-6-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3220	B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3220								
<i>2074 .050</i>	Dwg Rev: _____								
	Prog Rev: _____								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*B10-8-5*

*8*

*B10-8-8*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #  
Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

8.10/08/05

(X8)

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

11 10 08 05 (8)

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10 10/08/05

10 9

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Page 3

Item ID: D3220-3

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Item Name: Doubler

Start Date: 6/28/2010 Start Qty: 6.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg &amp; Stock Location: 180A

0.00



Packaging

Memo

0.00

Packaging

10/8/6 SP @ 80

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/09 J

mr

10-8-6

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 28, 2010 3:26:52 PM

Page 1

Work Order ID: 60212



Parent Item: D3220-3



Parent Item Name: Doubler



Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-06 JLM  
IPP: B 06.11.15 waterjet EC  
IPP C: 08.11.26 Comment added to step 2 KJ Verified by: eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	118.6947	0.5937	3.749684	4.8		
											18 10-8-5		

Location

Loc Qty

Loc Code

MAT22

118.6947

111381

22.3

113189

0.3947

114968

96

111381

8

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B  
MS21059L4 NUTPLATE  
MS20426AD3-3 RIVET, 2X  
4 PL

6

D3220-1/2 DOUBLER

**D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)  
D3220-042 (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs  
D3220-042 = 0.53 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AN INQUIRY  
WITHOUT NOTICE  
WORK ORDER  
NO. 60212  
3810-6-29

**RELEASED**  
2009-09-09

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3220	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NTS	
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8 7 6 5 4 3 2 1

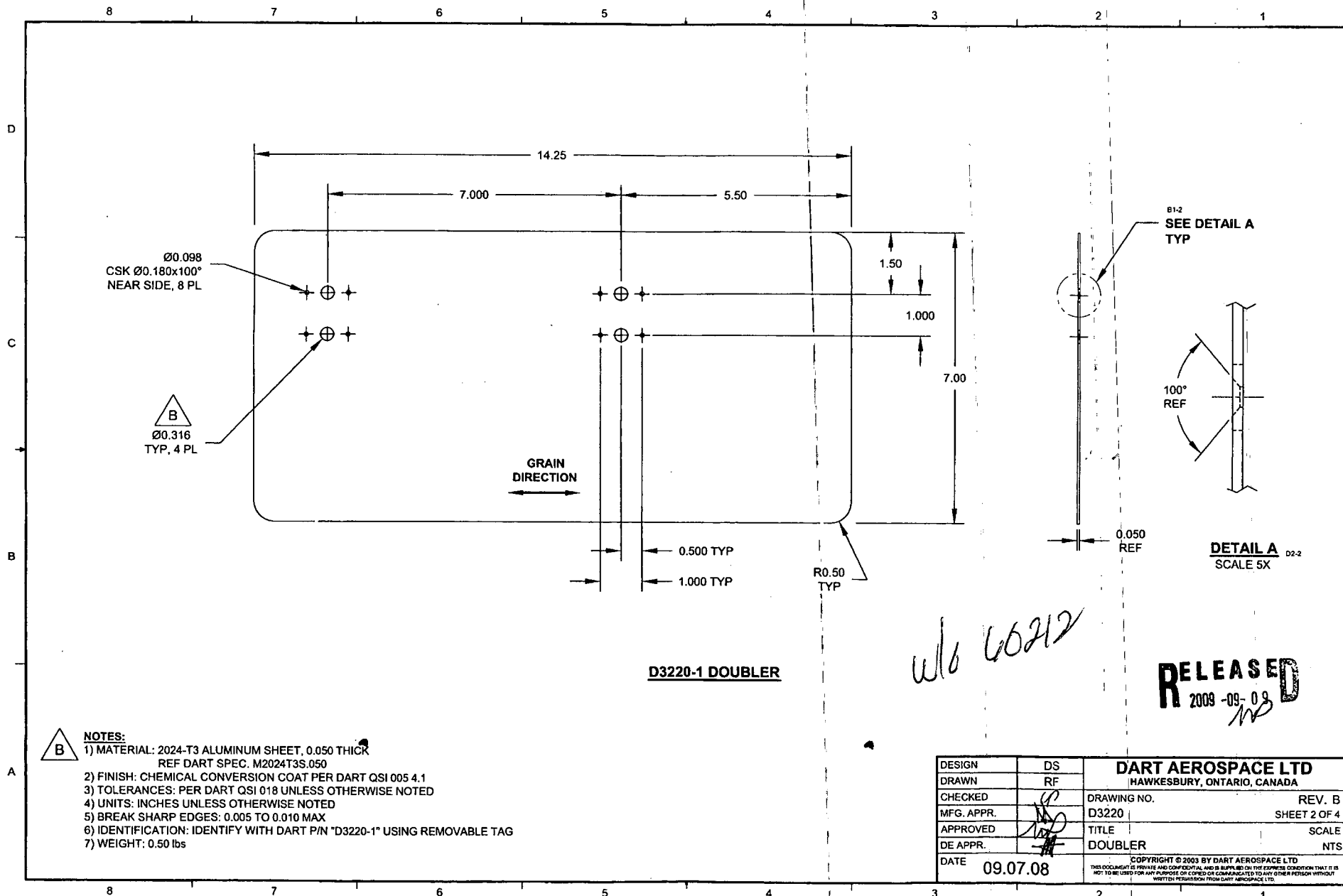
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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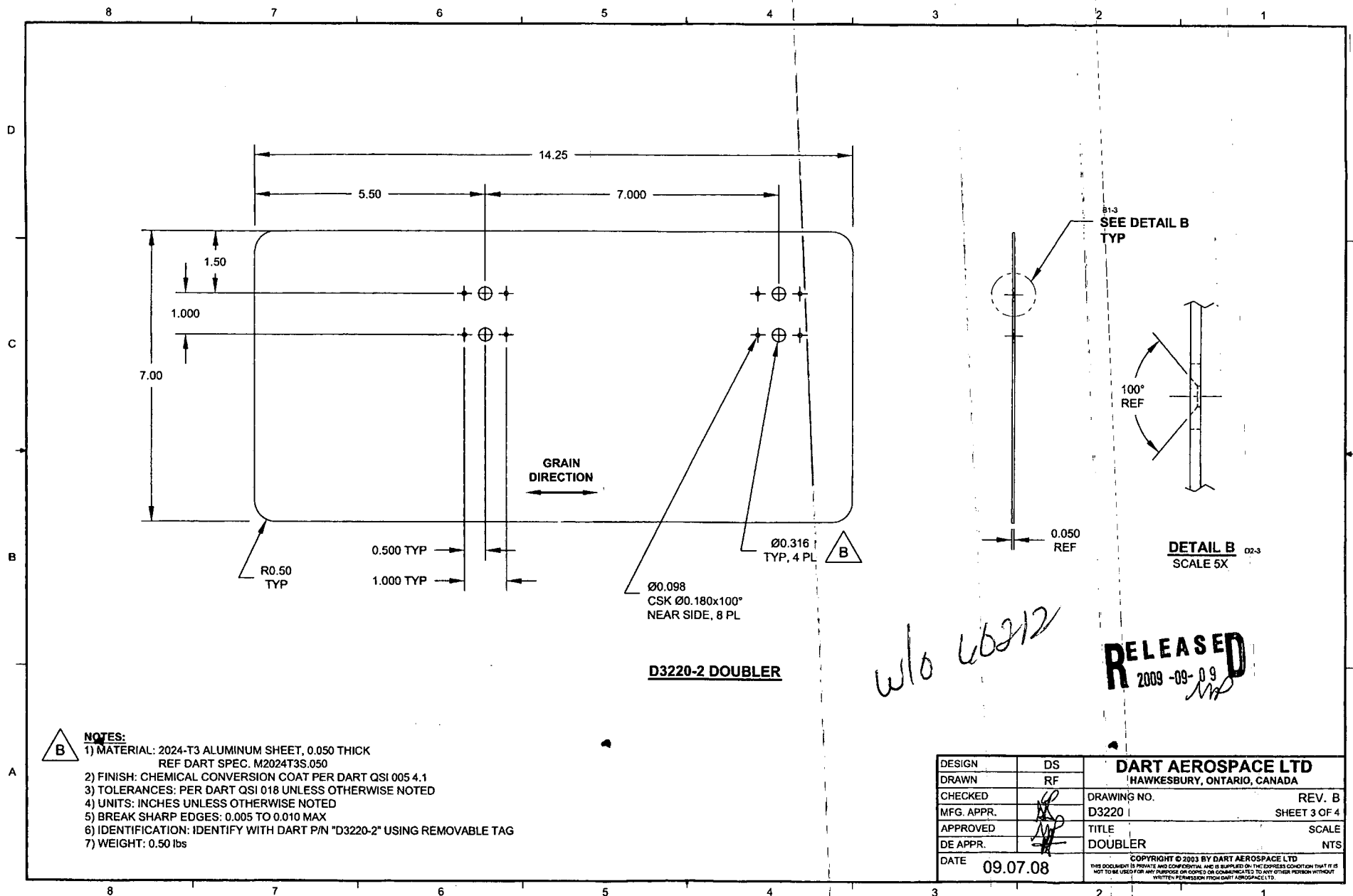
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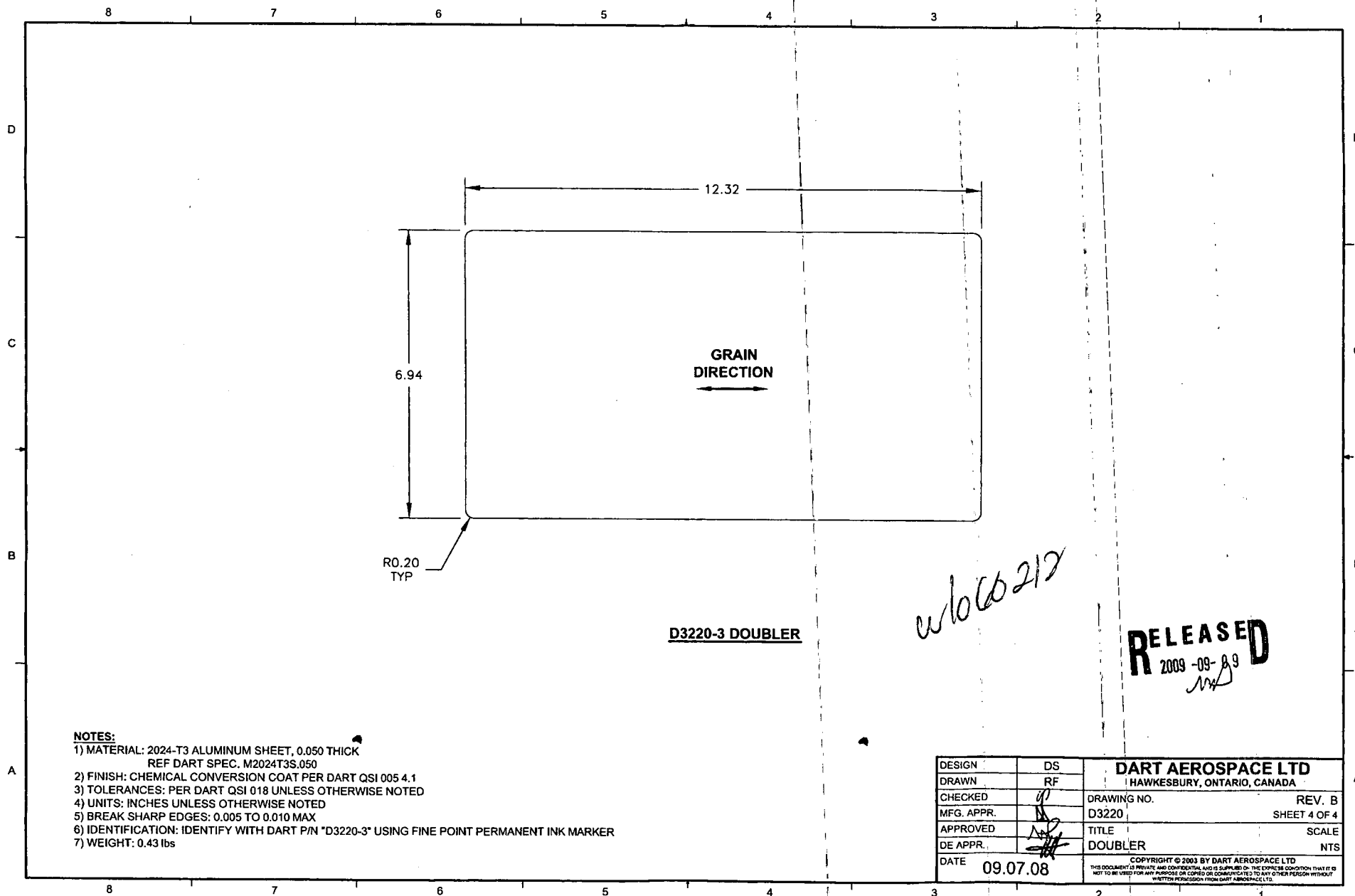
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**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JP</i>	D3220	SHEET 4 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
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